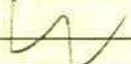
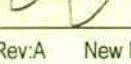


Date: Tuesday, 09/10/2007 2:55:19 PM
 User: Linda Lacelle

Process Sheet

Split #2

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 35032 -2	
Estimate Number : 12884	
P.O. Number : N/A	Part Number : D3560044
This Issue : 09/10/2007 S.O. No. : N/A	Drawing Number : D3560 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 35032	Material : N/A
Written By : 	Due Date : 19/10/2007 Qty: 10 Um: Each
Checked & Approved By : 	
Comment : Est Rev:A New Issue 07.05.24 EC	
Est Rev B ECN 987 07.10.09 EC verified by DD	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"

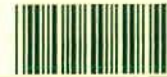


Comment: Qty.: 1.3598 f(s)/Unit Total : 13.5975 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: 5105450 SC 07.10.29 (10)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 15.500" long SC 07.10.29 (10)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: AA & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg: D3560 SC 07.10.29 (10)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE SC 07.10.29 (10)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK I.L 07/10/29

Date: Tuesday, 09/10/2007 2:55:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35032

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
PLATE *B 34478 = 1*

8/07.10.29 1

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560 *th*

(PTO) →

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) *th*
- 2- set up bracket and arm on jig *th*
- 3- preheat bracket and arm with torch *th*
- 4- clean before welding with brush *th*
- 5- set up machine to 135 amps *th*
- * 6- weld across bottom and top ends *th*
- 7- reheat with torch (*65*) *th*
- 8- on one side weld from bottom to top half way *th*
- 9- same for other side (half way) *th*
- 10- from half way point weld the rest of the first side (ease off pedal near end) *th*
- 11- same for remaining side (ease off pedal near end) *th*

8/07.10.29 1

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/07/10/31

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-31 ①

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 07/11/01 ①

Date

01.10.29

7.0

split w/o took $\frac{1}{2}$ from w/o -1 and left
9 pcs

JK
01.10.29

Date: Tuesday, 09/10/2007 2:55:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35032

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

07-11-01

①

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Spacer
batch: _____

~~✱~~

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

done on D3562-042 w/o

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

WIT

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
Doxilly

Job Completion



W 07.11.13

1870

1871

1872

1873

1874

1875

1876

1877

1878

1879

Date: Friday, 10/5/2007 10:58:45 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 35032		
Estimate Number	: 12884		
P.O. Number	:	Part Number	: D3560044
This Issue	: 10/5/2007 S.O. No. :	Drawing Number	: D3560 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: <i>8C</i>
Previous Run	: 34967	Material	:
Written By	:	Due Date	: 10/19/2007 Qty: 10 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07.05.24 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0500X05000	6061-T6 Bar 50" x 5.0"
-----	--------------------	------------------------



Comment: Qty.: 1.3598 f(s)/Unit Total : 13.5975 f(s)
 6061-T6 Bar 0.50" x 5.00"
 Batch: _____

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks 15.500" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: _____ & Dwg D3560 Rev: _____

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Date: Friday, 10/5/2007 10:58:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35032

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
PLATE

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART AEROSPACE LTD		Work Order:	35032
Description: Arm		Part Number:	D3560-4
Inspection Dwg: D3560	Rev: <i>EL</i>	Page 1 of 1	

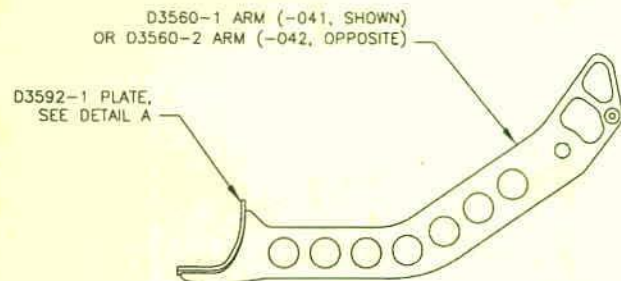
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

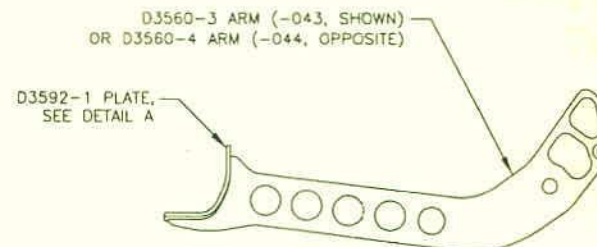
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	<i>.5065</i>	✓			
Ø0.196	+0.005/-0.001	<i>.1962</i>	✓			
Ø1.000	+0.010/-0.001	<i>1.0015</i>	✓			
Ø0.900	+0.010/-0.001	<i>.9000</i>	✓			
0.500	+/-0.010	<i>.4996</i>	✓			
0.250	+/-0.010	<i>.248</i>	✓			
0.275	+/-0.010	<i>.276</i>	✓			
0.188	+/-0.010	<i>.1892</i>	✓			
2.000	+/-0.010	<i>2.0000</i>	✓			
1.750	+/-0.010	<i>1.7500</i>	✓			
1.702	+/-0.010	<i>1.7015</i>	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	<i>.3850mm</i>	✓			
0.250 Deep	+/-0.010	<i>.248</i>	✓			

Measured by: <i>SE</i>	Audited by: <i>JL</i>	Prototype Approval:	N/A
Date: <i>02.10.21</i>	Date: <i>07/10/21</i>	Date:	N/A

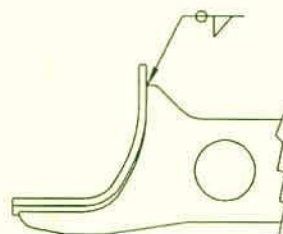
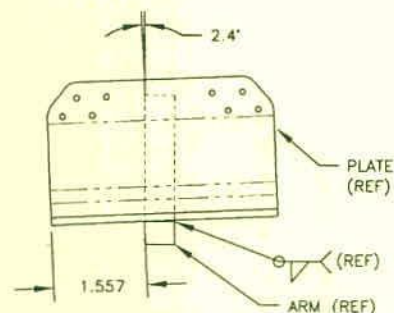
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM <i>JA</i>	<i>BE</i>



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

NO. 35032
WORK ORDER
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

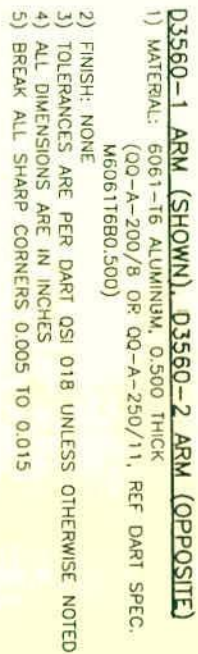
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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	GP	DRAWN BY GP
CHECKED	GP	APPROVED GP
DATE	07.06.19	TITLE
		ARM WELDMENT
		SCALE
		1:4

DART DART AEROSPACE LTD.
WARRICKSLEY, CHICAGO, CANADA

DRAWING NO. D3560
REV. C
SHEET 1 OF 3

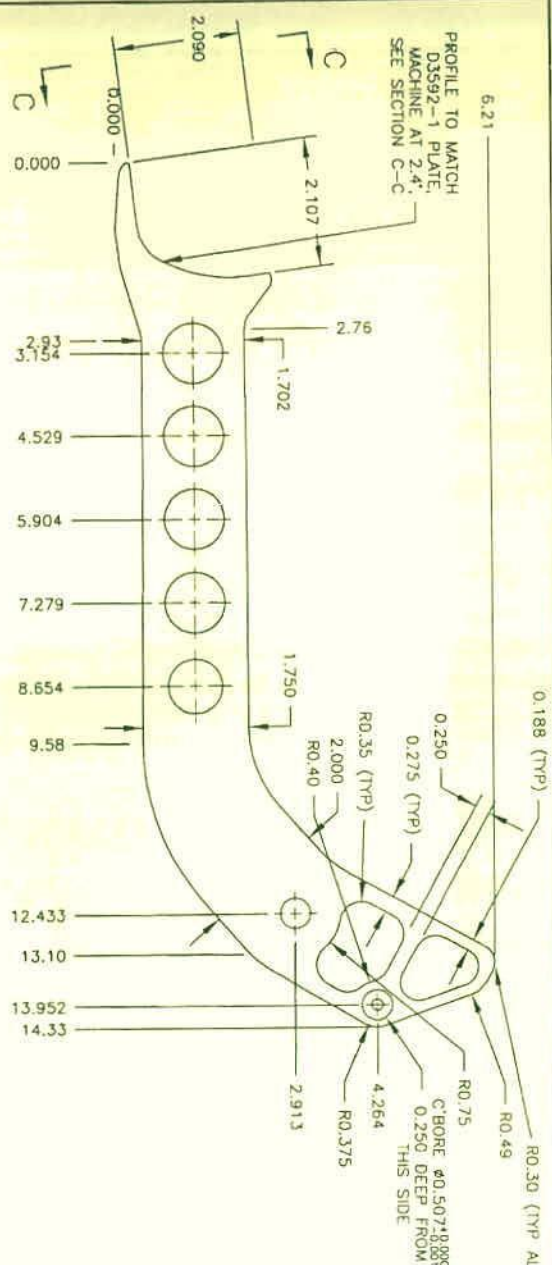


SCALE 1:1



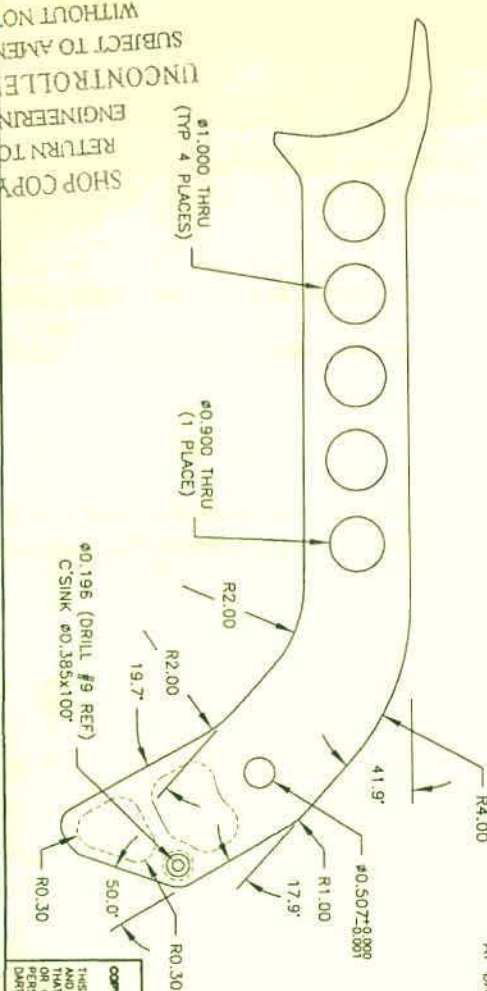
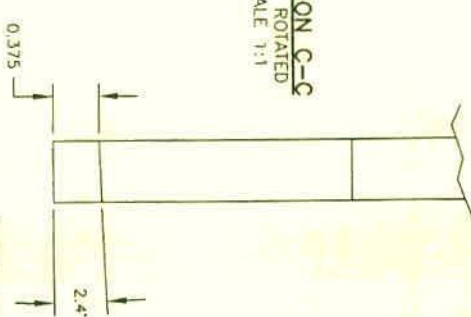
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NO. 755



- D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK (00-A-200/8 OR 00-A-250/11, REF DART SPEC. M606116B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION C-C
VIEW ROTATED
SCALE 1:1



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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
07.06.19	07.06.19	D3560	ARM WELDMENT
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE	DATE	TITLE	SHEET 3 OF 3
			SCALE

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07.06.19

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NO. 35032

